

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006526**Date Inspected:** 18-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #10 South and North Tower Shop

South Tower Lift #1:-Caltrans QA Inspector observed six welders performed FCAW process on the corner triangle plates that connected skin plate D and E. The corner triangle plates are located at elevation 18m to 47.6m double diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

South Tower Lift#2:- Caltrans QA Inspector observed four grinders and two welders performed grinding and FCAW repair process on rat holes of diaphragm that connected skin plate C. The rat holes are located at elevation 53m to 80.7m diaphragm section. The grinding and FCAW welding process are removing and repair the PJP welds that have been rejected by VT inspection. Base on Caltrans observation, no discrepancies were noted.

South Tower Lift #1:-Caltrans QA Inspector observed a welder performed FCAW repair process on outer corner longitudinal seam weld that connected skin plate A and E. The FCAW repair weld area have been repair by ZPMC UT test and located at elevation 43m to 47.6m diaphragm section. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Bay #11 East and West Tower Shop

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

East Tower Lift #1:-Caltrans QA Inspector observed three welders performed FCAW repair process on outer and inner corner longitudinal seam weld that connected skin plate A and E. The repair weld areas have been repair by ZPMC UT test and located at elevation 28m, 43m and 47.6m diaphragm section. The FCAW repair process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift #1:-Caltrans QA Inspector observed five ZPMC workers and two welders performed grinding and FCAW repair welding process on the fig lug welds and diaphragm welds. The fig lug welds and diaphragm welds are located at elevation 9m to 47.6m interior diaphragm of skin C. The grinding and welding process are removing and repair the fillet welds that have been rejected by ZPMC VT inspection. Base on Caltrans observation, no discrepancies were noted.

West Tower Lift#1:- Caltrans QA Inspector observed three ZPMC welders performed FCAW process on interior diaphragms. The interior diaphragms located at elevation from 9m to 47.6m of skin plate C. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

West Tower Lift#2:- Caltrans QA Inspector observed five ZPMC welders performed FCAW process on interior diaphragms. The interior diaphragms located at elevation from 53m to 80.7m of skin plate C. The FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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| Inspected By: | Pau,Wai | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
